
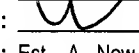


Date: Thursday, 28/06/2007 10:15:19 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : A119 BUBBLE WINDOW ASSY
Job Number : 33245	
Estimate Number : 12914	
P.O. Number : N/A	Part Number : D119755014
This Issue : 28/06/2007 S.O. No. : N/A	Drawing Number : D3624
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : THERMOFORMING	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 29/06/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est A New Issue 6/28/2007 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 119755014 CHG 1

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	33245A	A119 BUBBLE WINDOW
-----	--------	--------------------



Comment: Sub-Component A119 BUBBLE WINDOW

4.0	D2126	Seal
-----	-------	------



Comment: Qty.: 7.4372 f(s)/Unit Total : 7.4372 f(s) (7.50 f)

Seal

Batch# 632619

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/06/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/06/2007 10:15:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW ASSY

Job Number: 33245

Part Number: D119755014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119755014

Location:

PPP Rev:

part

E 11/12/29 (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/06/29

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

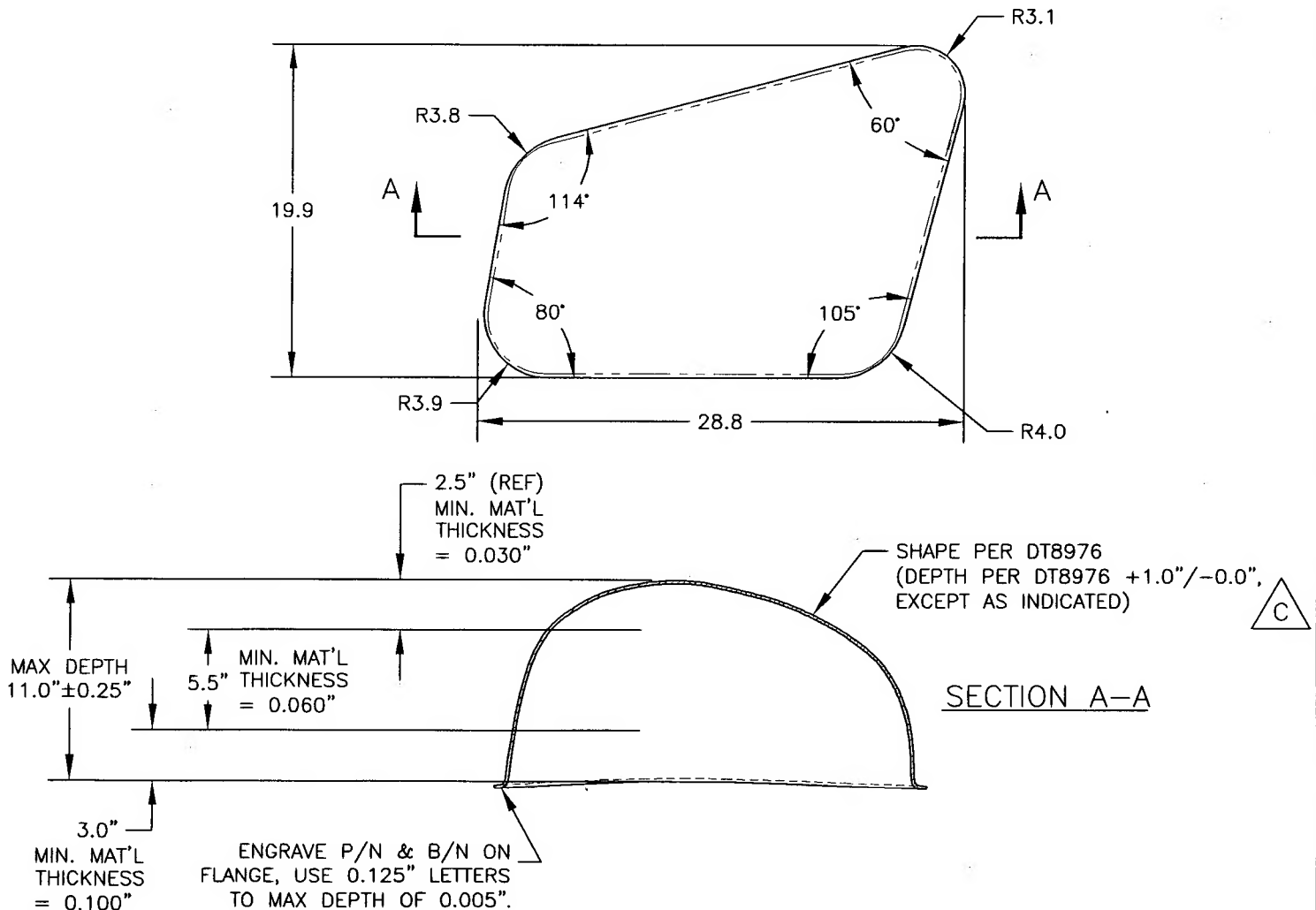
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	gp	DRAWN BY	gp	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#H	APPROVED	#H	DRAWING NO. D3624	SHEET 1 OF 1
DATE	07.06.27	TITLE	BUBBLE WINDOW (A119)	SCALE	1:10
A	07.05.14	NEW ISSUE			
B	07.05.24	11.0" DEPTH WAS 12.0"			
C	07.06.27	ADD TOOL TO CONTROL BUBBLE SHAPE			

RELEASED
07.06.28. #H**D3624-2 BUBBLE WINDOW**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK (REF DART SPEC. M-ACRYLIC-S.177)
- 2) FORM PER DT8953
FORMING PROCESS:
 - (a) DRAPE MAT'L OVER DT8953 MOLD
 - (b) HEAT TO 286°F
 - (c) VACUUM TO SPECIFIED HEIGHT
 - (d) LEAVE FOR AT 2 MINUTES TO COOL
 - (e) TRIM WINDOW PER DT8954
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33245A**

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Date: Thursday, 28/06/2007 10:15:20 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 BUBBLE WINDOW
Job Number	: 33245A		
Estimate Number	: 12911		
P.O. Number	:	Part Number	: D36242
This Issue	: 28/06/2007 S.O. No. :	Drawing Number	: D3624
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Drawing Revision	: REV. <i>A</i> Rev. C <i>07.06.28</i>
Previous Run	:	Material	:
Written By	: <i>W</i>	Due Date	: 29/06/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est. A Thermoform in house 6/27/2007 DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MACRYLICIS177	0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH
-----	---------------	--



Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)
0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SH

Mt. 10100655

Batch - M 104325

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

07.06.28 *Sh*

Trim Blank for Thermoformer

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Sh 07.06.28

Thermoform as per Dwg. D3624 Rev. *C* and Folio FTA 004 Rev. A

07.06.28 *DL*

Dwg. Rev. *E*

Folio Rev. *D*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

07.06.28 *DL*
SHAPE IS ACCEPTABLE
DL TO VERIFY DIMENSIONS.

Date: Thursday, 28/06/2007 10:15:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 BUBBLE WINDOW

Job Number: 33245A

Part Number: D36242

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

07.06.28 196.

Mark out with template and trim to finish dimensions.

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07.06.28 (V)

07.06.28 196.

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

N/A 2

8.0

HAND FINISHING2

HAND FINISHING RESOURCE #2



Comment: HAND FINISHING RESOURCE #2

Polish out mould marks.

Add cut out as per template provided by customer.

Etch Part# & Batch #

07.06.28 196.
07.07.03 196.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/03 07.06.28 (V)

inspected the cut out performed on 07/07/03 by DL

10.0 RFE PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

07/7/03 (V) 33245

11.0

QC21

FINAL INSPECTION/W/O RELEASE

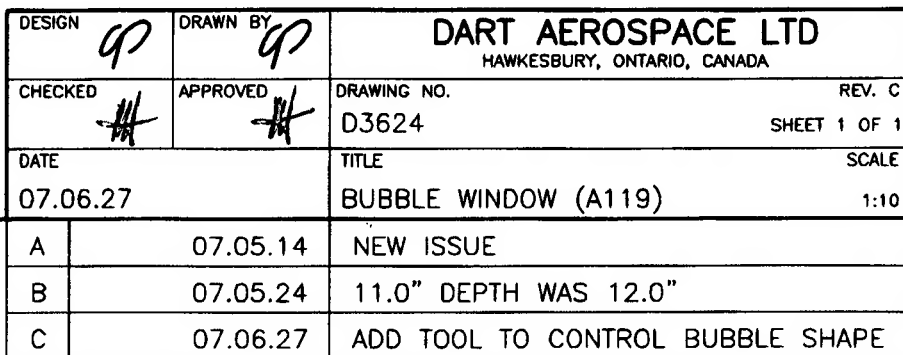


Comment: FINAL INSPECTION/W/O RELEASE

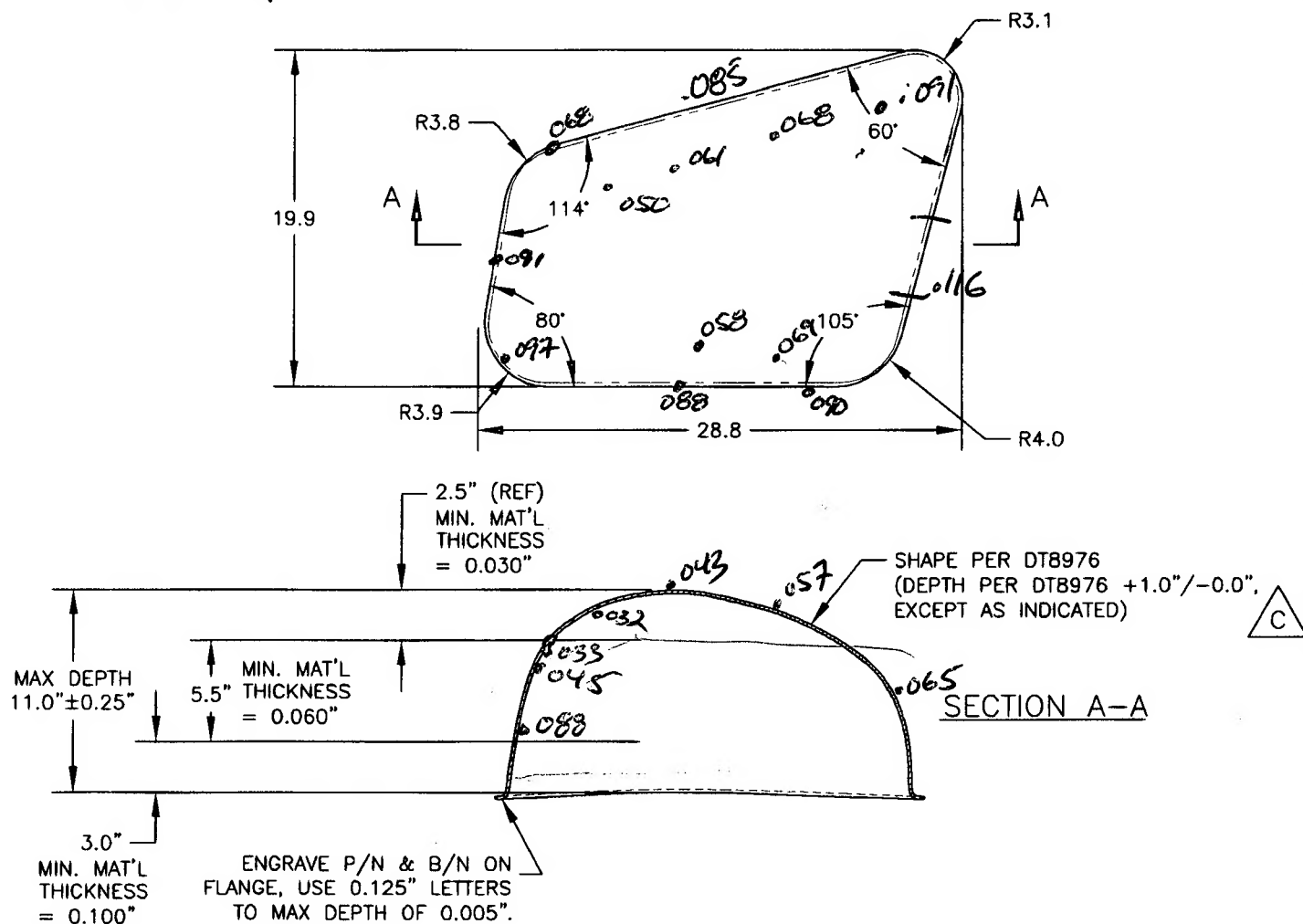
Job Completion



07.06.29



RELEASED
07-06-28



1) MATERIAL: POLYCAST II CLEAR ACRYLIC OR PLEXIGLAS "G" CAST ACRYLIC, 0.177" THICK
(REF DART SPEC. M-ACRYLIC-S.177)

2) FORM PER DT8953

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